

Date: Tuesday, 7/1/2008 2:34:29 PM
User: Kim Johnston

Dart Aerospace Ltd.

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPAD
Job Number : 40191
Estimate Number : 12785
P.O. Number :
This Issue : 7/1/2008 S.O. No. :
Prsht Rev. : NC Part Number : D356411
First Issue : 11 Type : SMALL /MED FAB Drawing Number : D3564 REVD
Previous Run : 39133 Drawing Revision : D
Written By : Due Date : 7/16/2008 Qty: 20 Um: Each
Checked & Approved By :
Comment : Est Rev:A New Issue 07-03-08 ec
Est Rev:B As per Rev C 07-07-09 JLM
Est Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M304S16GA 304/316 063 Sheet

Comment: Qty.: 1.4805 sf(s)/Unit Total : 29.6100 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: 108156 RB 8-7-14

2.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3564 ***** (D3564-1F)*****
Dwg Rev: D RB 8-7-14
Prog Rev: D
2-Deburr if necessary RB 8-7-14

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE

Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3564 using Jigs DT 317A and DT 8155

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40191

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Ensure joggle as per dwg D3429

08/7/14 (422) *ccntd*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description
A/R 2059B Hardcoat

Batch

M108631

Weld hardcoat as per Dwg D3437

13
EL 8-7-21

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

08/12/22 (43)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/12/22 (43)

10.0

POWDER COATING

POWDER COATING



M106442



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:40
320 °F
9:10

M-L 08/07/22

(13)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-07-22

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP -19

M-L 08/07/22

(13X)

Date: Tuesday, 11/12/2000 2:04:28 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 40191

Part Number: D356411

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



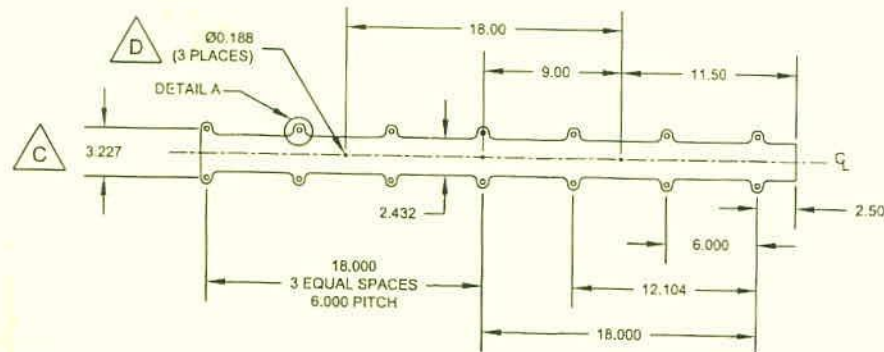
08/07/22 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

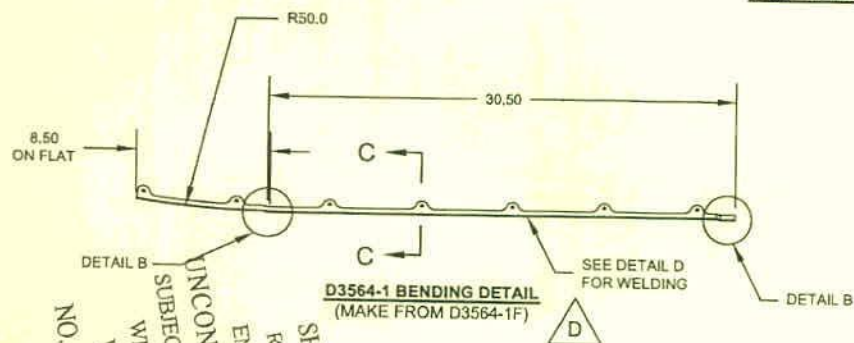
Job Completion



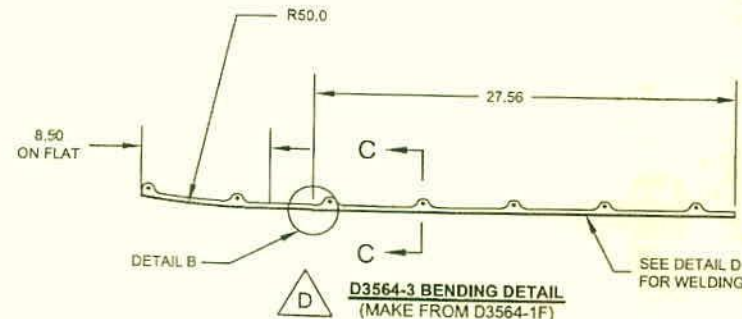
MF 08-07-22



D3564-1F FLAT PATTERN



D3564-1 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-3 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

07.09.04

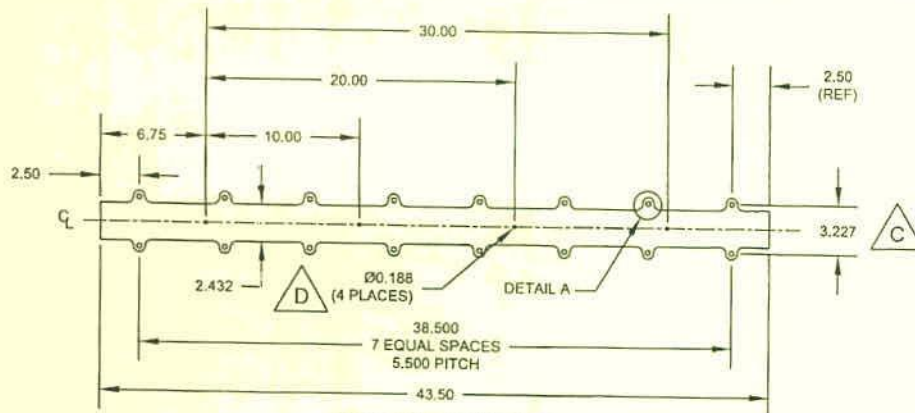
NO. 40191
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:

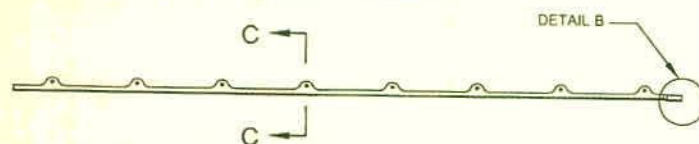
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDING (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

WEIGHTS:	
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

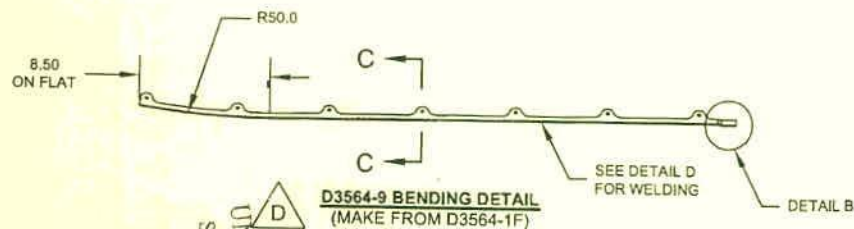
D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	PH		
APPROVED	PH		
DE APPR.	PH		
DATE	07.08.21		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO.		REV. D	
D3564		SHEET 1 OF 3	
TITLE		SCALE	
WEARSHOE		1:	
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D3564-5F FLAT PATTERN

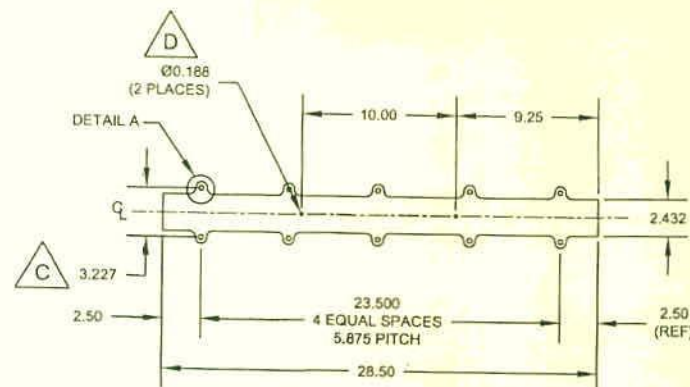


D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)

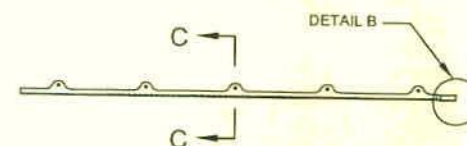


D3564-9 BENDING DETAIL
(MAKE FROM D3564-1F)

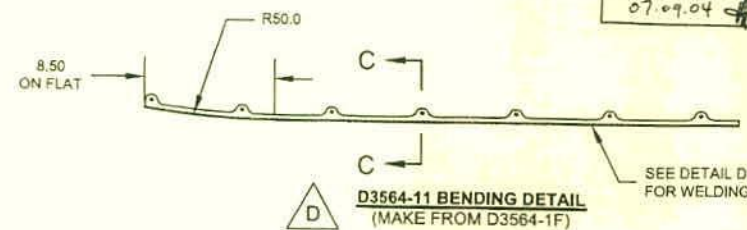
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D3564-7F FLAT PATTERN



D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



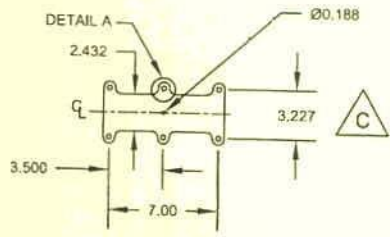
D3564-11 BENDING DETAIL
(MAKE FROM D3564-1F)

RELEASED

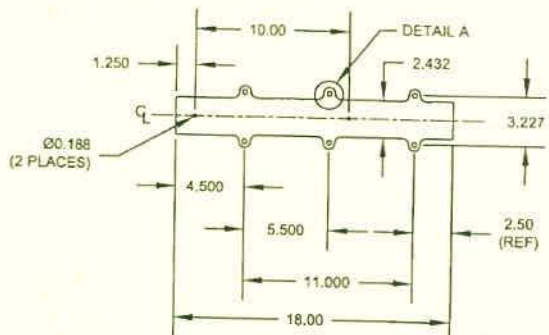
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APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	1:8
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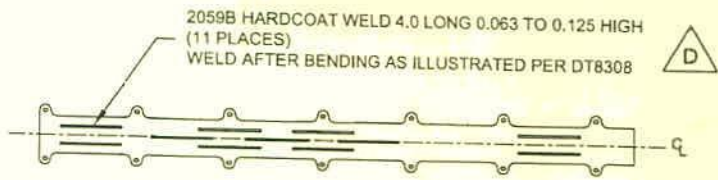
8 7 6 5 4 3 2 1



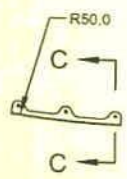
D3564-13F FLAT PATTERN



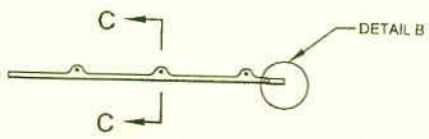
D3564-15F FLAT PATTERN



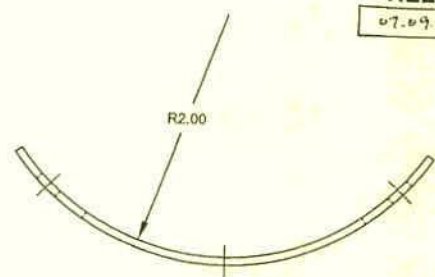
DETAIL D
(D3564-1/-3/-9/-11 WELDING DETAIL)



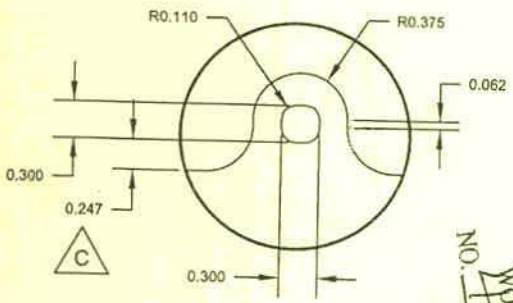
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



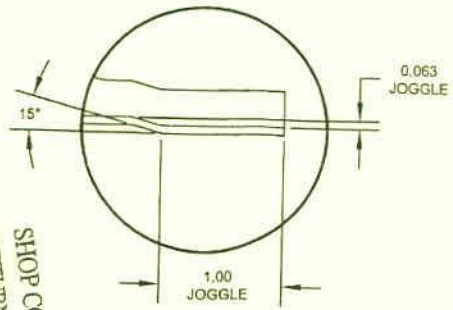
D3564-15 BENDING DETAIL
(MAKE D3564-15 FROM D3564-15F)



SECTION C-C
SCALE 1:1



DETAIL A
SCALE 1:1



DETAIL B
SCALE 1:1

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07.07.04

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CHECKED	PH	DRAWING NO.	REV. D
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APPROVED	PH	TITLE	SCALE
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